

Work Order ID 67473

Tuesday, March 22, 2011 2:22:07 PM



Page 1

Item ID: D4016-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Half, Base

Start Date: 3/22/2011 Start Qty: 18.00



Cust Item ID:

Required Date: 3/29/2011 Req'd Qty: 18.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-03-22 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D4016	A								

100	Cut blanks as per folio	0.00							
Bandsaw									
Jeaspa Bandsaw									

Memo

CUT BLANK 1.00" LONG

0.00

Y.A 11/03/23

18

φ

110		0.00							
HAAS 1									

Memo

MACHINE AS PER FOLIO FA869 AND DWG
FOLIO REV: AA
DWG REV: A

0.00

Y.A 11/03/28

18

φ

HAAS CNC vertical machine #1

DEBURR

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		H.A 11/03/28		18	0		
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		ant 11/03/29		18	0		
160 Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo	0.00 0.00		SAP 11-04-03 (18)					

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Page 3

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Revision ID:

Stop



Item Name: Hinge Half, Base

Start Date: 3/22/2011 Start Qty: 18.00



Cust Item ID:

Required Date: 3/29/2011 Req'd Qty: 18.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

N/11-04-4

18

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, March 22, 2011 2:22:14 PM

Page 1

Work Order ID: 67473

Parent Item: D4016-1

Parent Item Name: Hinge Half, Base



Start Date: 3/22/2011

Required Date: 3/29/2011

Start Qty: 18.00

Required Qty: 18.00

Comments: IPP REV:A NEW ISSUE 09-11-27 JLM VERIFIED BY :DD IPP Rev:B
as per dwg REV.A DD 10.02.22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B1.000X1.000		Purchased	No			100	f	17.6790	0.08	1.44			

304 bar 1.00 x 1.00

Location

MAT050

Loc Qty

17.67897768

Loc Code

113290

5.67897768

117130

12

1.44

B.A 11/03/23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	47473
Description: Hinge Half, Base		Part Number:	D4016-1
Inspection Dwg: D4016 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.875	+/-0.010	0.875	✓		Vern	GA-01
0.25	+/-0.030	0.244	✓		Vern	GA-01
0.38	+0.030/-0.000	0.390	✓		"	"
R0.03	+/-0.030	R0.030	✓		R-6	ref.
0.13	+/-0.030	0.135	✓		Vern	GA-01
0.88	+/-0.030	0.875	✓		"	"
Ø0.257	+0.006/-0.001	Ø0.259	✓		"	"
R0.38	+/-0.030	R0.375	✓		R-6	ref.
0.500	+/-0.030	0.501	✓		Vern	GA-01
0.75	+/-0.030	0.751	✓		"	"

Measured by: B.A	Audited by: [Signature]	Preliminary Approval:
Date: 11/03/28	Date: 11/03/29	Date:

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ [Signature]	[Signature]

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

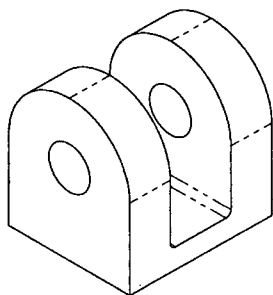
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

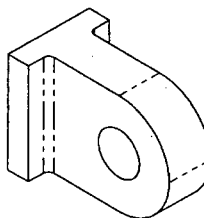
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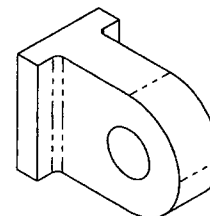
SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 67473
RS 11-03-22



D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID



D4016-5 HINGE HALF, LIGHT LID

RELEASED
 2010-02-16
MD

A	NEW ISSUE		JPH	10.01.29
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A	
MFG. APPR.	<i>[Signature]</i>	D4016	SHEET 1 OF 2	
APPROVED	<i>[Signature]</i>	TITLE	SCALE	
DE APPR.	<i>[Signature]</i>	BASKET HINGE	NTS	
DATE	10.01.29	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

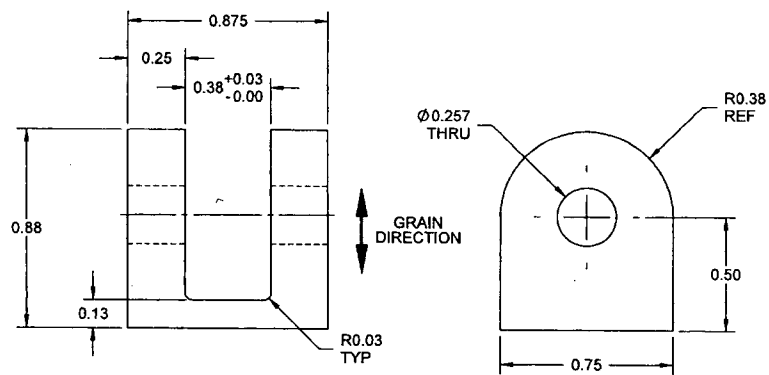
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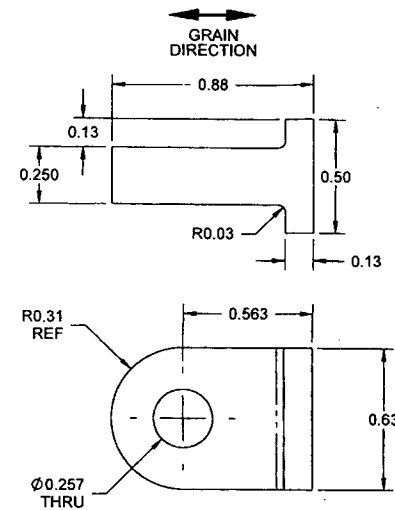
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D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID

D4016-5 HINGE HALF, LIGHT LID

NOTES:

1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR,
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4180)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT -1: 0.09 lbs

-3: 0.04 lbs

-5: 0.01 lbs

RELEASED
2010-02-16

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4016	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET HINGE	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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